

Work Order ID 56135

February 10, 2010 2:56:14 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 2/10/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-2-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

) 4101216

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 		0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends								
	2- C'sink holes as per dwg without cutting fluid								
	3- Prepare tube for welding, remove alodine as required.								
	4- Scribe batch number insied aft end of tube.								
130 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

4/10/2/16

Siddiqui

FLO

W/O:		WORK ORDER CHANGES					
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QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

m113207

BE 10/02/17

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

m113207

BE 10/02/17

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

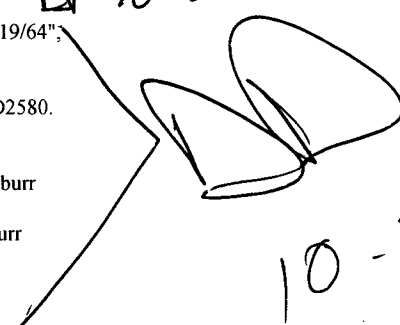
DP 10-2-22

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur



10-2-23

Pho →

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-634-041 PAR #: _____ Fault Category: Shield tubes NCR: Yes No DQA: _____ Date: 10-03-16
 Resolution: re-work Disposition: re-work QA: N/C Closed: _____ Date: 10/03/16

NCR: <u>50135</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/02/23	# 140.6	tube moved on table while drilling. Aff cap hole. causing hole to be closed. R.C. Bad Luck find this morning. Process	<i>[Signature]</i>	- Fill hole in with weld As per QST 004 A/12/01/2007	BE 10/02/23	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
			<i>[Signature]</i>	- Grind weld flush inside + out side of tube.	BE 10/02/23	<i>[Signature]</i>	<i>[Signature]</i>	10/02/23
			<i>[Signature]</i>	- Redrill hole in correct location.	BE 10/02/23	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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150

QC10- Inspect visual per QSI004- ground welds

0.00

S 10/02/24

QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

S 10/02/24

QC

Memo

0.00

Quality Control

170

Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

PAR 09-043

BL 10-3-1

D.

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

=> JH 10/03/01

(X1)

Ø



Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:30pm
OVEN TEMPERATURE: 320°C
FINISH TIME: 3:00pm

190

QC3- Inspect Part Finish

0.00

BH 10-03-3

①



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐☐☐ Sikaflex-291 M112345
Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐☐☐ Sikaflex-291 M112345
Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 113462

BR 10-03-3 ①

W/O:		WORK ORDER CHANGES					
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210

QC5- Inspect part completeness to step on W/O

0.00

S. 10/17/04

QC

Memo

0.00

(+0)

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

*PP 58359**6/13/05 (1)*

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/05
MF 10-3-05

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 56135



Parent Item: D205-634-041



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Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev: O 06.02.28 Added paperwork EC
 IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2580-1		Manufactured	No			110	Each	5.0000	1.0000			



205 Skidtube bent detail

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

54541

54697

54721

13 56123

5

2

2

1

W 10/2/16

D2576-3

Manufactured No

140

Each

141.0000

1.0000



Step (maching detail)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

46661

52215

141

94

47

1 BE 10/02/17

Dart Aerospace Ltd

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2579		Manufactured	No			140	Each	147.0000	20.0000			



Crossbolt Spacer



Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

LG	25	
----	----	--

51525	4	
-------	---	--

53780	3	
-------	---	--

54543	18	
-------	----	--

Main Warehouse

ST	122	
----	-----	--

43988	4	
-------	---	--

46434	4	
-------	---	--

46956	2	
-------	---	--

47797	9	
-------	---	--

48272	2	
-------	---	--

51314	71	
-------	----	--

51315	30	
-------	----	--

B 56145



BE 10/02/17

February 10, 2010 2:56:19 PM

Shop Packet Print

Page 2

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2855		Manufactured	No			200	Each	151.0000	1.0000			



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST026	151	
50513	1	
50770	1	
51539	39	
53791 ✓	110	

AN3-5A

Purchased

No

200

Each

1,773.000 2.0000



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1773	
100188 ✓	188	
105057 ✓	1585	

1 BL 10-03-3

2 BL 10-03-3

Dart Aerospace Ltd

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Start Qty: 1.00

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IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960JD10L		Purchased	No			200	Each	3,459.000	2.0000			



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 3459

101291 16

105793 49

110985 ✓ 3394

ALS7-1032-130 Purchased No

200 Each 986.0000 50.0000



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 110511 986

108606 52

111529 130

111779 34

112772 11

113238 759

ALS4-1032-130

2 BR 10-03-3

50 BR 10-03-3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN3C4A		Purchased	No			200	Each	1,263.000	50.0000			
BOLT												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1263
112314	13
112720	12
112724	3
112829	1
112991	2
113121	64
113226	344
113422	124
113644	500
113749 ✓	200

50 BR 10-03-3.

AN960C10L Purchased No



washer

200 Each 388.0000 50.0000



Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 113737	100
103585	100

50 BR 10-03-3.

Main Warehouse

ST	288
112116	128
112612	160

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3566-13		Manufactured	No			200	Each	83.0000	1.0000			
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

81

53461 ✓

81

Main Warehouse

ST

2

45717

1

50265

1

D3566-5

Manufactured No

200

Each

34.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19

30

55026 ✓

18

55335

12

Main Warehouse

ST

4

36113

1

46186

1

47318

1

51260

1

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Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3566-1		Manufactured	No			200	Each	39.0000	2.0000			
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP	34	
52512	3	
54480	1	
55011	3	
55320 ✓	27	

2 BR 10-03-3

Main Warehouse

ST	5	
46349	1	
51218	1	
51259	3	

D3564-11

Manufactured No

200

Each

5.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19 55332	3	
52125	3	

1 BR 10-03-3

Main Warehouse

ST	2	
45823	1	
50112	1	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 8

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Work Order ID: 56135



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3564-13		Manufactured	No			200	Each	23.0000	1.0000			
Wearshoe												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP17

11

51611 ✓

11

Main Warehouse

ST

12

45409

2

46495

10

D3564-9 Manufactured No

200

Each

14.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP19

12

55025 ✓

12

Main Warehouse

ST

2

44659

1

45825

1

1 BL 10-03-3

1 BL 10-03-3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56135



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3564-5		Manufactured	No			200	Each	44.0000	1.0000			



Wearshoe

Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	40	
51925	1	
54772 ✓	13	
55024	12	
55333	14	
Main Warehouse		
ST	2	
45824	1	
47433	1	

✓ DL 10-03-3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 10

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Work Order ID: 56135



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2594-3		Manufactured	No			200	Each	668.0000	16.0000			



O-Ring, 205 Skidtube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	527	
51613	27	
55546	500	
Main Warehouse		
ST	141	
52562	141	

16 10-03-3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56135



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 102.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2594-1		Manufactured	No			200	Each	705.0000	16.0000			



Plug, 205 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 577

54008 1

54643 15

55002 ✓ 561

Main Warehouse

ST 128

42221 16

42807 92

43884 3

46435 2

51527 9

51757 6

16.00 10-08-3.

February 10, 2010 2:56:19 PM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36135

BS 10-210

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

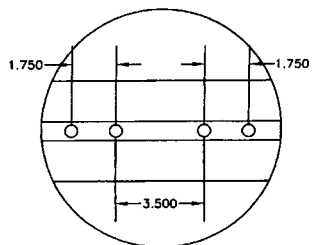
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

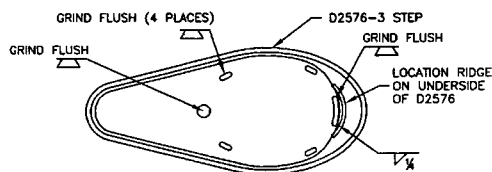
NOTE: Date & initial all entries

W/O 56135

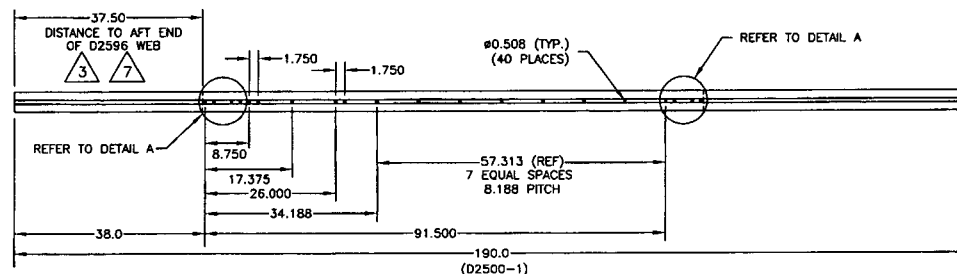
DETAIL A
SCALE 5:24



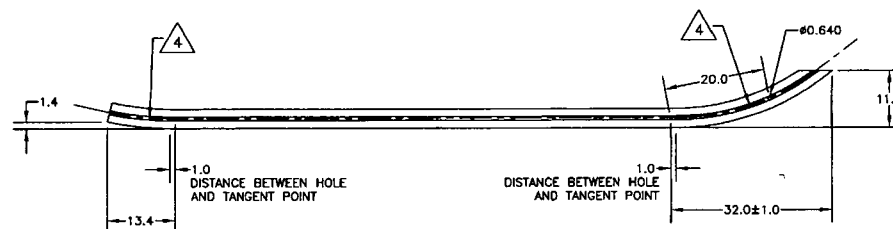
DETAIL B
SCALE 5:24



D2580-1 DRILLING DETAIL

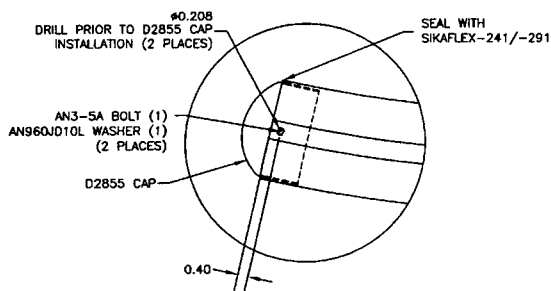


D2580-1 BENDING AND CUTTING DETAIL

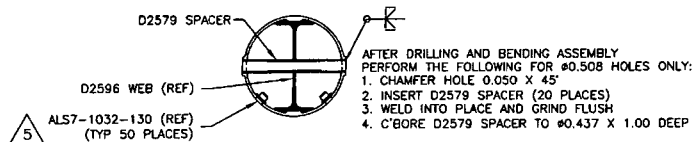


RELEASED
07.06.28

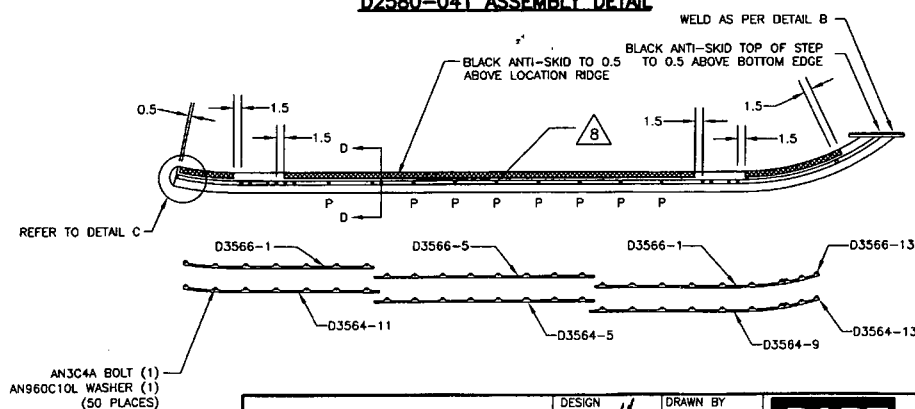
DETAIL C
SCALE 5:24



SECTION D-D
SCALE 5:24



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. 0
		D2580	SHEET 2 OF 3
DATE	TITLE	SCALE	
07.02.27	205 SKIDTUBE ASSEMBLY	1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 226

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 56134
Part number: D205 634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P.D. Date of Test Coupon 10-02-23

Welder Barclay Elliott Date of Test Coupon 10-02-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld